



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3910-3
Job Sheet 188254



Part No: D3910-3

Job Qty: 20 pcs

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: ~~1/18/19~~ 1/21/2019

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEETS 1,3 IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP REV:C 18.02.02 REMOVE FINISH DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	20 pcs	1/18/19	1/18/19	0.00	0.00	Purchasing - 1	5	JAN 08 2019
							Purchasing - 2	5	
							Purchasing - 3	5	
120	Packaging 2-1 - Receive - B4B	20 pcs	1/18/19	1/18/19	0.00	0.00	Packaging 2 - 1 - B4B		JAN 08 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		
							Packaging 2 - 29 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S142702



Part: D3910-3

Job No: 188254

Serial No/Batch: S142702

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/08/19

				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	DAS
130 QC 6	20 pcs	1/18/19	0.00 0.00	QC 6 - 38	38
				QC 6 - 42	9-89
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
180 Packaging 3-1 - Stock - B4B	20 pcs	1/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	51523 98 JAN 15 2019
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	JAN 15 2019
190 QC 21 - SA	20 pcs	1/18/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
					9-89

Part Op 110 - (Purchasing) ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005
 Descriptions: 120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure C of C is attach
 130 - (QC6- All purchased or subcontracted products)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	2.5000 ft (.125 ea)	110-Purchasing	5142701
D3910-3P	Crosstube Lug	20 pcs (1 ea)	110-Purchasing	5142700

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	3	508	0
	D3910-3P	20	0	0

Part Specifications

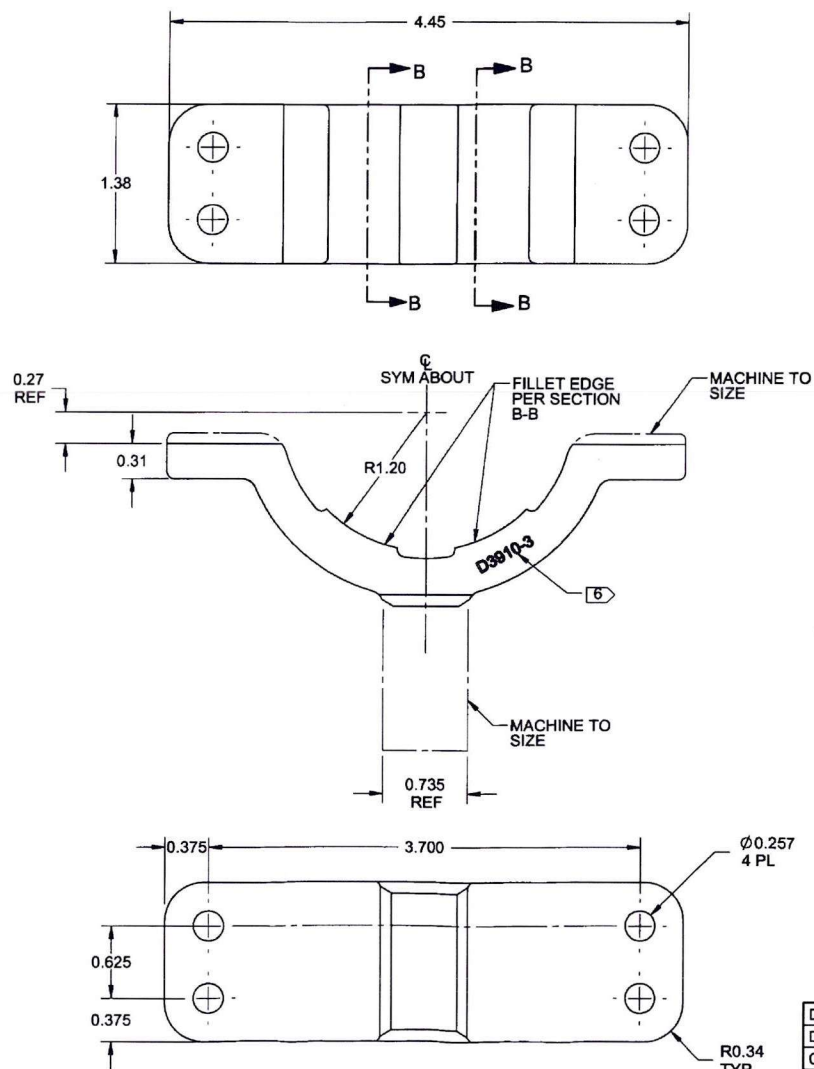
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches ± 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches ± 0.030	1.410 1.350		
3	Crosstube Lug	0.080Inches ± 0.020	0.100 0.060	Radius	
4	Crosstube Lug	0.270Inches ± 0.030	0.300 0.240	reference	
5	Crosstube Lug	0.310Inches ± 0.030	0.340 0.280		
6	Crosstube Lug	0.735Inches ± 0.010	0.745 0.725	reference	
7	Crosstube Lug	1.200Inches ± 0.030	1.230 1.170	Radius	
8	Crosstube Lug	3.700Inches ± 0.010	3.710 3.690		
9	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365		
10	Crosstube Lug	0.625Inches ± 0.010	0.635 0.615		
11	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365		
12	Crosstube Lug	0.340Inches ± 0.030	0.370 0.310	Radius	
13	Crosstube Lug	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
14	Crosstube Lug	0.100Inches ± 0.010	0.110 0.090		
15	Crosstube Lug	45.000Degrees ± 0.500	45.500 44.500	angle	
16	Crosstube Lug	1.410Inches ± 0.030	1.440 1.380	Reference	

Plex 1/4/19 2:43 PM Dart.lajeunesse.marie

SECTION B-B



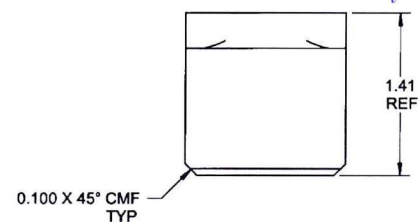
ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-3 X-TUBE LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 188254MOS
1901-03



RELEASED

2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	21	D3910	SHEET 3 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	140	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Items

Grand Total: \$348.00

Plex 1/7/19 1:09 PM dart.Lussler.Patrick



METAL TECHNOLOGY INC.

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Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24484
Shipment Date: 07-Jan-2019
Ship Via: Pick up at METEC
Order Number: 3342
Order Date: 01/07/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO042188
Terms: Net 60 Days

----- Quantity -----							Job	
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>
1	20	20	0	0	EA	DART-D3910-3P Crosstube Lug alodined and painted as per QSI005	E	3342-01

DAS
38
2-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
20	D3910-3	Cross Tube Lug	E	B101186	30600	42188

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, January 7, 2019

DA:
38
9-89